

**Work Order ID 57749**

April 14, 2010 11:37:01 AM



Page 1

Item ID: D2364

Accept



Setup Start



Revision ID:

Stop



Item Name: Deck Plate, Fwd 350 Litt

Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2364

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2364 ☐ Dwg Rev: F ☐ Prog Rev: F ☐ 2-  
Deburr if necessary

B10-4-19

2024 .063

(7)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-4-19

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S1064123

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 57749**

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Item Name: Deck Plate, Fwd 350 Litt

Stop



Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- counter sink holes as per dwg D2364-2- deburr if necessary

*Handwritten signature and date: 4/10/04/26*

*Handwritten circled number: 6*

*Handwritten circled number: 10*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Handwritten: Sustained**Handwritten circled number: 46*

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00


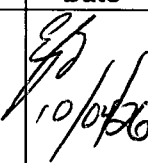
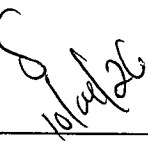


*Handwritten circled number: 16*

*Handwritten date: 18-4-27*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2364 PAR #: N/P Fault Category: 5m fab NCR: Yes No DQA: 10 Date: 10.05.03  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: 10/05/03 Date: 10/05/03

NCR: <u>57749</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/04/26	130	1 part <del>hole</del> e'sink hole .338 are Too deep. set moved RC Process		Scrap & destroy Qty x1 no replace	 10/04/26	 10/04/26		 10/04/26

NOTE: Date & initial all entries

# Work Order ID 57749

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Item ID: D2364

Accept



Setup Start



Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Stop



Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

START TIME:

11:30AM

FINISH TIME:

OVEN TEMPERATURE:

320°F

7 J 10/04/27 6 0

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Ⓟ BL 10-4-27.

180



Packaging

Packaging

Identify as per dwg & Stock Location

225

0.00

Memo

0.00

10-4-28 Ⓟ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 57749

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Page 4

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Revision ID:

Item Name: Deck Plate, Fwd 350 Litt

Stop



Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/29 *[Signature]*

BS 10-4-29  
⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 57749



Parent Item: D2364

Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 4/14/10

Required Date: 4/16/10

Comments: IPP REV. E 00.06.26 Removed P/O for powder coat EC  
IPP Rev:F Now On Waterjet 06-07-03 JLM

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	260.0000	4.0857	4.8		



2024-T3 .063 sheet



1810-4-19

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT22

260

111787

2

113866

24

113867

42

114351

192

113866

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 57749
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b> D2364
<b>Inspection Dwg:</b> D2364	<b>Rev:</b> F	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.629	✓			
Ø0.171	+0.005/-0.000	.175	✗			
0.354	+/-0.010	.360	✓			
11.242	+/-0.010	11.248	✓			
3.031	+/-0.010	3.035	✗			
1.903	+/-0.010	1.904	✓			
1.128	+/-0.010	1.134	✓			
0.354	+/-0.010	.355	✓			
1.340	+/-0.005	1.343	✗			
2.326	+/-0.010	2.323	✗			
3.312	+/-0.010	3.315	✗			
4.298	+/-0.010	4.296	✗			
5.284	+/-0.010	5.286	✗			
6.151	+/-0.010	6.154	✗			
6.270	+/-0.010	6.274	✓			
0.354	+/-0.010	.352	✓			
3.031	+/-0.010	3.033	✓			
Ø0.656	+0.005/-0.000	.658	✗			
5.003	+/-0.010	5.003	✗			
4.605	+/-0.010	4.603	✓			
1.776	+/-0.010	1.774	✓			
0.980	+/-0.010	.981	✗			
4.487	+/-0.010	4.488	✓			
7.192	+/-0.010	7.196	✓			
7.567	+/-0.010	7.569	✓			
7.942	+/-0.010	7.940	✗			
Ø0.191	+0.005/-0.000	.193	✓			
Ø0.197	+0.005/-0.000	.199	✓			
11.145	+/-0.010	11.144	✓			
12.181	+/-0.010	12.181	✓			
11.378	+/-0.010	11.378	✗			
11.776	+/-0.010	11.779	✗			
12.173	+/-0.010	12.173	✓			
4.690	+/-0.010	4.692	✗			
0.250	+0.005/-0.000	.250	✓			
3.141	+/-0.010	3.141	✓			
Ø0.171	+0.005/-0.000	.174	✓			
Ø0.171	+0.005/-0.000	.173	✗			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-4-19	<b>Date:</b> 10/04/03	<b>Date:</b>	N/A

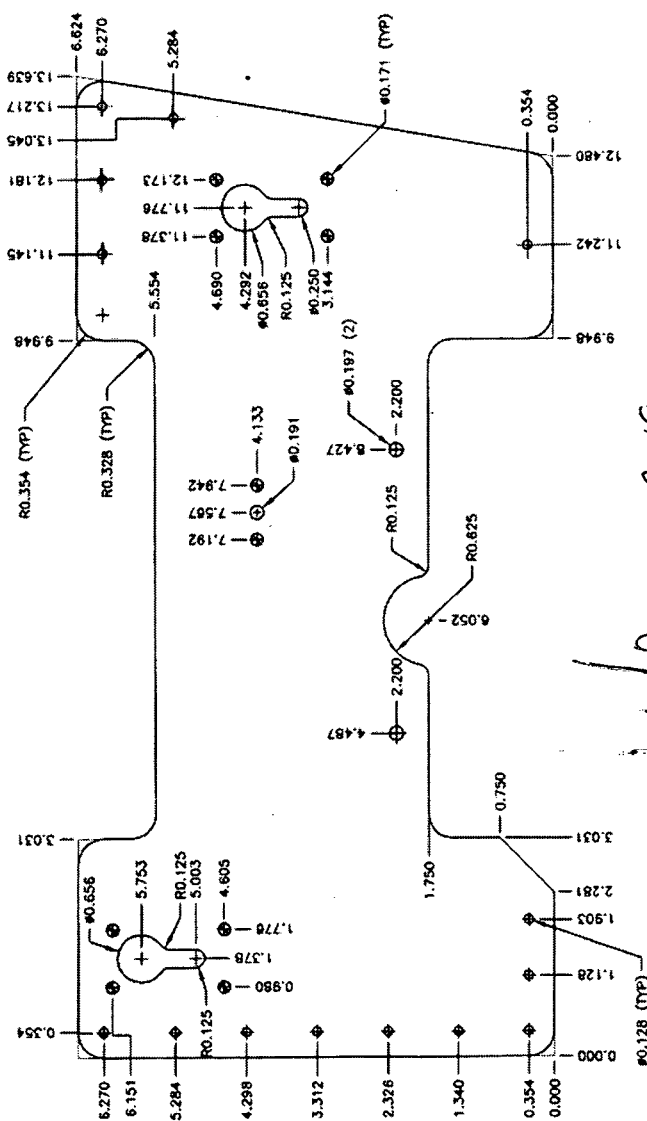
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	



DESIGN <i>KE</i>		DRAWN BY <i>KE</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DPA</i>		APPROVED <i>CA</i>		DRAWING NO. D2364 REV. F SHEET 1 OF 1	
DATE 98.06.19		TITLE LITTER DECK PLATE, 350		SCALE 2:5	
A	95.01.14	NEW ISSUE			
B	95.02.09	MOVED KEYWAY			
D	95.03.06	0.191 WAS 0.197			
E	95.10.06	GEOMETRY CHANGES			
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)			

RELEASED  
99/06/22 KG

COUNTER SINK HOLES:  
 \* C'SINK Ø0.225 x 100° (UPDATED FROM 9 TO 14 HOLES BY DS 99.03.01 TO CORRECT CAD ERROR)  
 \* C'SINK Ø0.308 x 100°



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK  
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED